Date:

Tuesday, 01/04/2008 3:45:00 PM

User:

Julie Lecocq

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 38274

**Estimate Number** 

: 10324

P.O. Number

Previous Run

This Issue

: 01/04/2008

Prsht Rev. First Issue

: NC

: 01/04/2008

: 36465

Type : MACHINED PARTS **Part Number** 

**Drawing Name** 

: D1049

**Drawing Number** 

: D1049 REV A : N/A

: SADDLE BLOCK

**Project Number Drawing Revision** 

Material **Due Date** 

: 24/04/2008

Qty:

50 Um: Each

Written By

Checked & Approved By

S.O. No. :

Comment

: Est RevC 02.04.10 Re-format NG

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

M6061T6B0750X00250

6061-T6 Bar .750 x .250



Comment: Qty.:

0.1749 f(s)/Unit Total :

Material: 6061-T6 bar .750 wide x .250 thick.

Batch M 107904

08/05

2.0

SHEAR

SHEAR



Comment: SHEAR BAND SAW

Cut Blanks: 2.000" long

HAAS CNC VERTICAL MACHINING #1



3.0

HAAS1

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio FA217 & Dwg D1049

2-Deburr

INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC2



Comment: INSPEC PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK

Comment: SECOND CHECK

Dart Ae	rospac	e Ltd			•					
W/O:				WORK ORDER	CHANGES					
DATE	STEP	·		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		1						,		
·										
Part No		P	AR #:	Fault Category:	NCF	t: Yes	No <b>DQ</b>	A:	Date:	·
						QA: N	/C Close	d:	_ Date: _	·
NCR:	•		\	WORK ORDER NON-CON	FORMANCE	(NCR	(1)			· · · · · · · · · · · · · · · · · · ·
				Corrective Actio	n Section B					

NCR:			WORK ORD	ER NON-CONFORMANC	E (NCR)			
<u></u>	ATE STED Description of NC			Corrective Action Section B		Varification	Annroval	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Verification Section C Approval Chief Eng	
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NOTE: Date & initial all entries

Tuesday, 01/04/2008 3:45:01 PM Date: User: ↑ Julie Lecocq **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: SADDLE BLOCK Job Number: 38274 Part Number: D1049 Job Number: Seq. #: Description: **Machine Or Operation:** HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 POWDER COATING 7.0 10 5 642 **Comment: POWDER COATING** Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVE 8.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: U 28-26-10 10.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES	3				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
Part No	•	PAR #: Fault Category: I	NCR: Yes	s No DQ	A:	_ Date: _	
•			QA:	N/C Close	d:	_ Date: _	

NCR:			WORK OR	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Annroyal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Saddle	Part Number:	D1049
Inspection Dwg: D1049 Rev:		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

		X First A	rticle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
Ø0.203	+0.005	.203					
1.380	+/-0.010	1.379					
0.75	+/-0.030	753				,	
0.25	+/-0.030	254					
0.90	+/-0.030	.90	/	_			
0.17	+/-0.030	.172	/_				
R0.250	+/-0.010	1-250					
0.38	+/-0.030	-350				*****	
1.80	+/-0.030	1.805					
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Measured by:	J.L.	Audited by	V: Chy	/	Prototype App	roval:	N/A

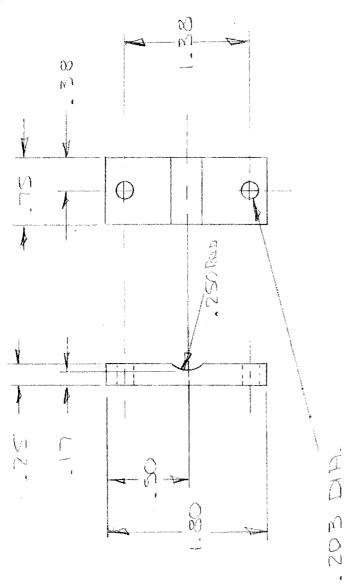
Measured by:	JL	Audited by:	Prototype Approval:	N/A
Date:	08/06/02	Date: 7 62.00	2.04 Date:	N/A

Rev	Date	Change		proved
Α	03.10.07	New Issue	KJ/RF OK OTTO	**tov
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MATERIAL CONSTRUCTION

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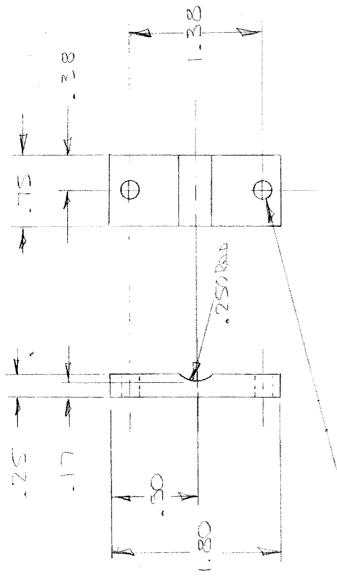
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